

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015656**Date Inspected:** 14-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. The following observations were:

OBG Trial Assembly Yard:

OBG Seg 9AW to Seg 9BW:

This QA Inspector observed the following work in progress:

The repair welding of weld joint no: EP111-001-014. The welding process was identified as Shielded Metal Arc Welding (SMAW). The welder was identified as 045196. The ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair-1 (WRR No: B-WR-13942 Rev-0).

OBG Seg 9CE to Seg 9DE:

This QA Inspector observed the following work in progress:

ZPMC personnel performing the base metal repair welding on Deck Panel of OBG Seg 9CE & 9DE. The welding

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process was identified as SMAW. The welder was identified as 062092. The ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-1G(1F)-Repair-1. The repair welding was performed after the removal of the temporary attachments and performed in accordance with Critical Welding Report (CWR): CWR 1679R1.

See attached photo for further details.

OBG Seg 9DE to Seg 9EE:

This QA Inspector observed the following work in progress:

The Flux Cored Arc Welding (FCAW) process on weld joint no's: BP181-001-020, 022, 024, 026, 028 & 030. The welder was identified as 067942. The ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-T.

The FCAW process of weld joint no's: BP127-001-020, 022, 024, 026, 028 & 030. The welder was identified as 067947. The ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-T.

Cross Beam's (CB):

1) Bay 7: CB18.

This QA Inspector observed the following work in progress:

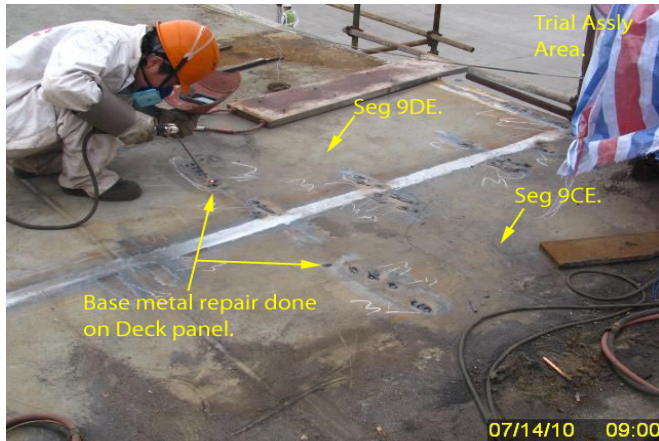
ZPMC personnel performing the fit-up operation of stiffener X3724B with Bottom Panel BP3055A. The tack welding process was identified as SMAW. The welder is identified as 049485. The ZPMC Quality Control (QC) is identified as Cui Jun Jie. The welding variables recorded by QC appeared to comply with WPS-B-P-2112. This QA Inspector performed a random visual inspection of the tack welds and the results appeared to comply with the contract documents.

See attached photo for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer